

Work Order ID 162743

Monday, June 12, 2017 11:33:52 AM

162743

Page 2

Item ID: SK145-0114-23**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop *NS2*****Item Name:** Collar**Start Date:** 6/26/2017 **Start Qty:** 5.00***5*****Cust Item ID:****Required Date:** 7/3/2017 **Req'd Qty:** 5.00***5*****Customer:****Reference:** SCHEDULED/C**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

17/7/4 JG



JUL 03 2017

Picklist Print

Monday, June 12, 2017 11:34:00 AM

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Work Order ID: 162743

162743

Parent Item: SK145-0114-23

SK145-0114-23

Parent Item Name: Collar

Start Date: 6/26/2017

Required Date: 7/3/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 17.06.06 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
84735K117		Purchased	No			110	Each	50.0000	1	5			

84735K117

Cap

**

DAS
30
9-89

JUL 01 2017

Location

Loc Qty

Loc Code

ST586

50

m137748

50

5

D

C

B

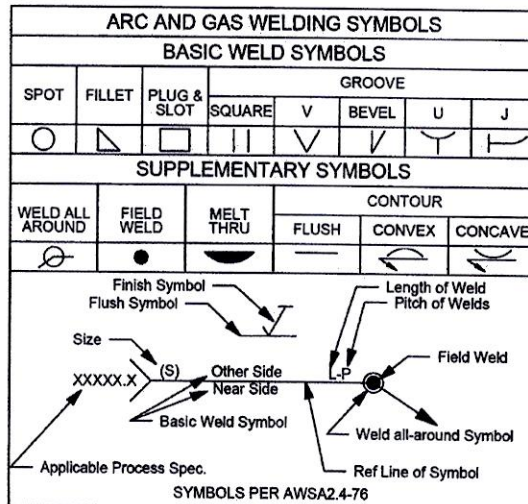
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NOTES:

1. INTERPRET DRAWING IAW ASME Y14.100
2. UNLESS OTHERWISE SPECIFIED, HOLES INDICATED WITH 3 PLACE PRECISION (ϕ .XXX) TOLERANCED IN ACCORDANCE WITH ASME B4.1-1967 CLASS LC 11 (HOLE H13).
3. CALCULATED FASTENER LENGTHS SHOWN. ACTUAL FASTENER LENGTHS TO BE DETERMINED AT INSTALLATION.
4. FUSION WELDING IN ACCORDANCE WITH AWS D1731 CLASS A UNLESS OTHERWISE SPECIFIED.
5. FUSION WELDING INSPECTION TO BE ACCOMPLISHED VISUALLY.
6. POWDER COAT NON ID SURFACES, EXCEPT SURFACE OF ITEM 02 TO WHICH ITEM 26 WILL BE BONDED, USING IFC COATINGS CUSTOM YELLOW P747 PT. OVERSPRAY ACCEPTABLE.
7. IDENTIFY MANUFACTURED PARTS PER MIL-STD-130 AS FOLLOWS: [CAGEC] [PN] [REV].
EXAMPLE: 81205 1234567890-501 A
8. SCUFF THE BOTTOM OF ITEM 26 AND THE TOP OF ITEM 02 PRIOR TO ADHERING THEM TOGETHER
9. BOND ITEM 26 TO ITEM 02 USING ONE OF THE FOLLOWING:
 - ITEM 45
 - CA40 (3M)
 - ITEM 46 WITH ITEM 47
 IF CA40 OR ITEM 46 WITH ITEM 47 ARE USED, PRIME SURFACE WITH ITEM 48 IN ACCORDANCE WITH MANUFACTURES INSTRUCTIONS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162143A
JUN 12 2017

REVISION HISTORY			
SYM	DESCRIPTION	DATE	APPROVAL



AR 48	PR200	METAL PRIMER	REMA		
AR 47	SC2000	CEMENT	REMA		
AR 46	UTR20	HARDENER	REMA		
AR 45	495	ADHESIVE	LOCTITE		
1 44	B219BA111	BOLT	MTL SPEC		
1 43	NAS1149F0463P	WASHER	MTL SPEC		
1 42	MS35338-44	WASHER	MTL SPEC		
1 41	MS21042L4	BOLT	MTL SPEC		
1 40	8473SK117	CAP	75A DIROMETER, BLACK		
1 28		-28 HOOK PAD	EPDM		
1 25		-25 FITTING	AISI 301 AXL AMS 5901		
1 24		-24 HOOK	HOT ROLLED STEEL SHEET	.125	
1 23		-23 COLLAR	8473SK117 CAGEC 30428		
1 22		-22 BUSHING	AISI 301 AXL AMS 5901	ϕ .438	
1 21		-21 GRIP	BLACK VIEVD VINYL	1.5	
1 20		-20 TUBE	2024-T3 AL ALY AMS-Q2-A-620/4	ϕ 1.000 X .080 WT	
05					
04					
03					
02					
01					
-05					
-04					
-03					
-02					
-01					
QTY REQD	PART NUMBER	DESCRIPTION	MATL/SOURCE	STOCK SIZE	NOTES

LIST OF MATERIALS

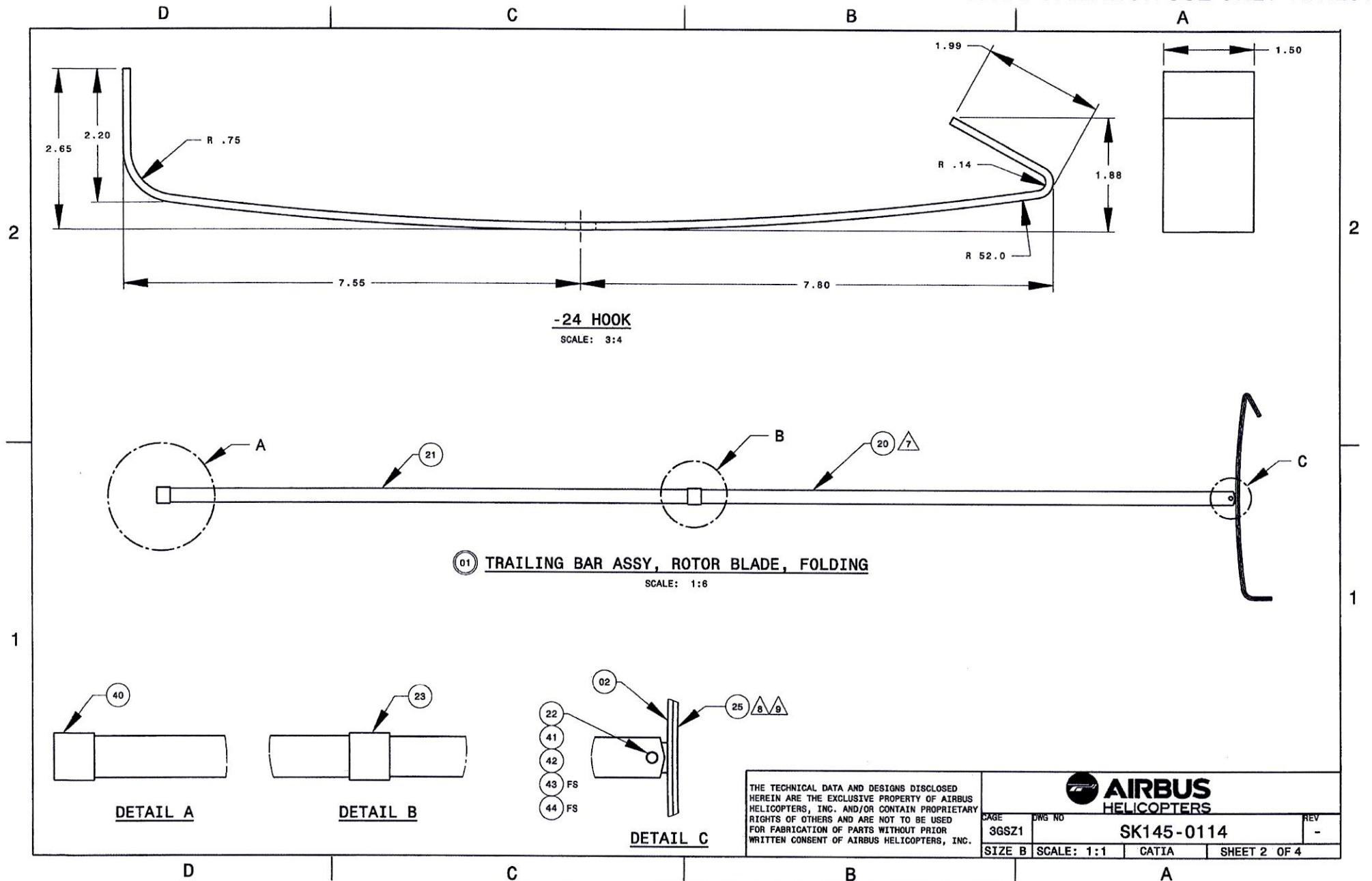
UNLESS OTHERWISE SPECIFIED, DIM ARE IN INCHES TOL ON ANGLES $\pm$.5° 1 PLACE $\pm$.1 2 PLACE $\pm$.03 3 PLACE $\pm$.010 INTERPRET DIM AND TOL PER ASME Y14.5-1994		DRAWING RELEASE ORDER 145-0981 NAME DATE 3/23/16 3/23/16 3/23/16 2/3/15		 AIRBUS HELICOPTERS TITLE TRAILING BAR ASSY, ROTOR BLADE, FOLDING CAGE 3GSZ1 DWG NO SK145-0114 SIZE B SCALE: NONE CATIA SHEET 1 OF 4	
THE TECHNICAL DATA AND DESIGNS DISCLOSED HEREIN ARE THE EXCLUSIVE PROPERTY OF AIRBUS HELICOPTERS, INC. AND/OR CONTAIN PROPRIETARY RIGHTS OF OTHERS AND ARE NOT TO BE USED FOR FABRICATION OF PARTS WITHOUT PRIOR WRITTEN CONSENT OF AIRBUS HELICOPTERS, INC.		NEXT ASSEMBLY		REV -	

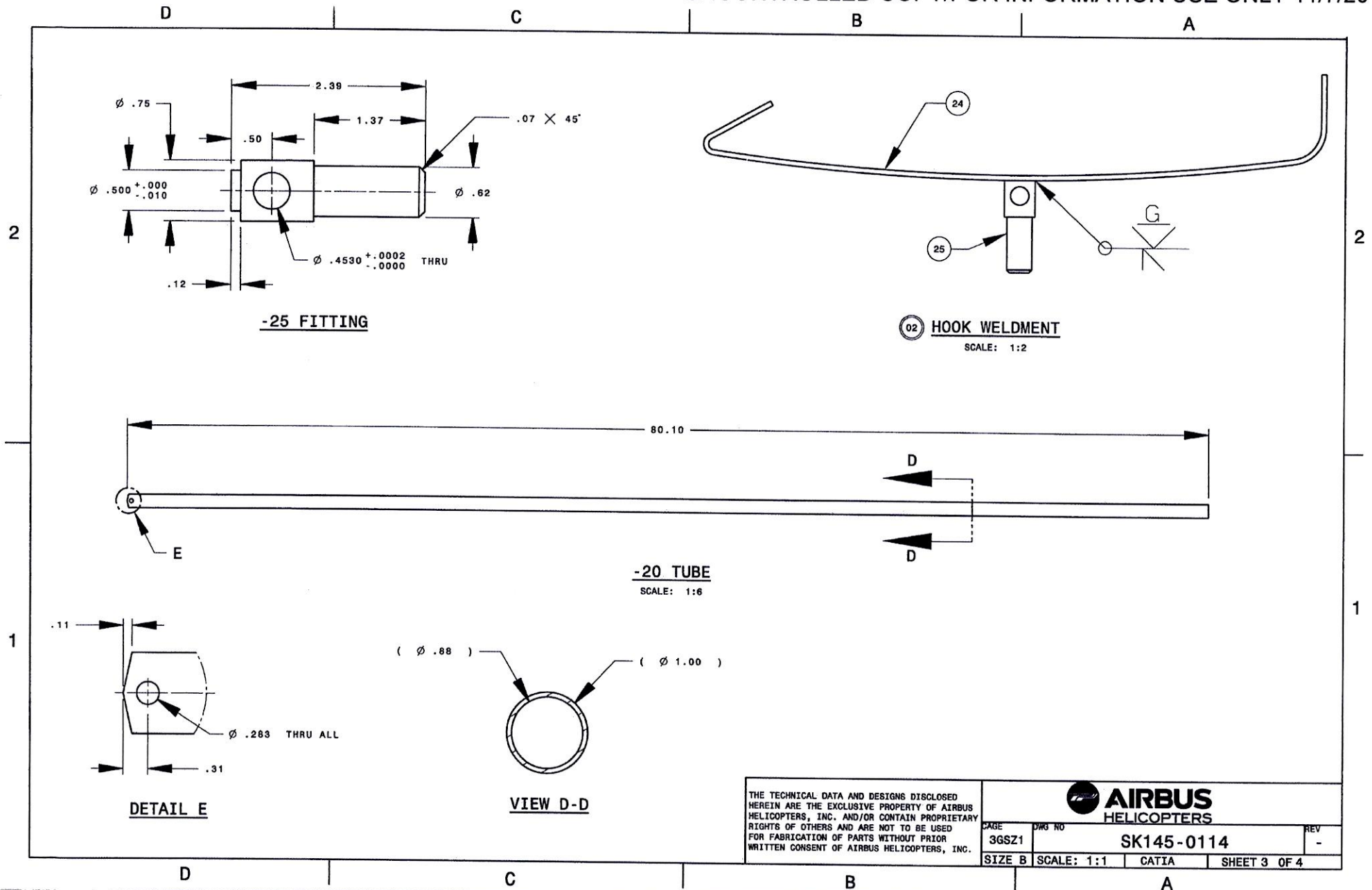
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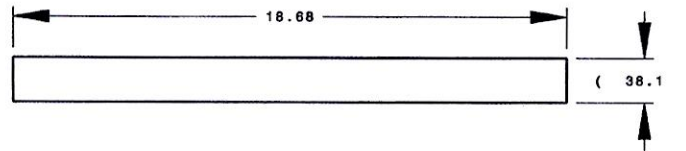


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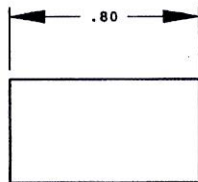
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-26 HOOK PAD

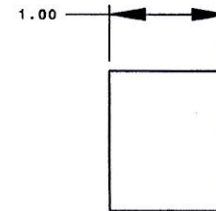
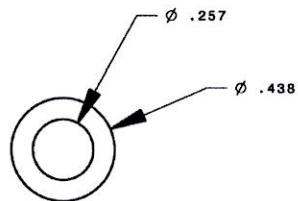
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2



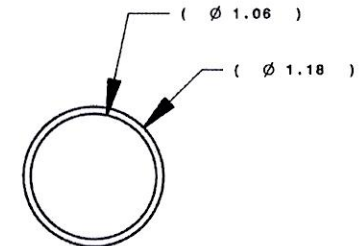
-22 BUSHING

SCALE: 2:1



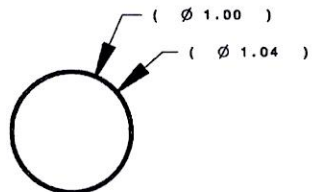
-23 COLLAR

SCALE: 1:1



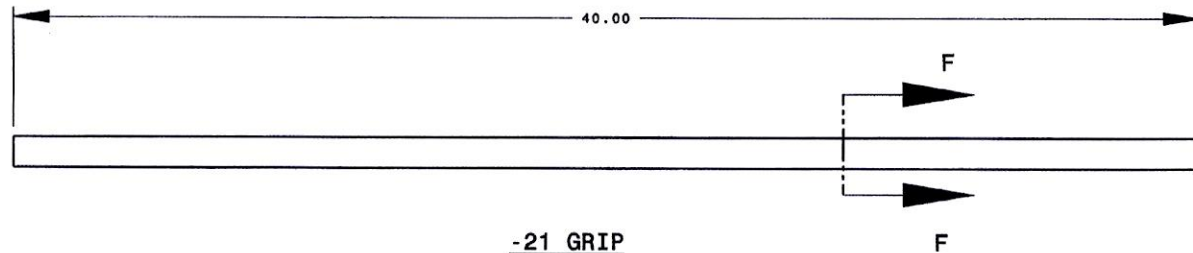
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1



VIEW F-F

SCALE: 1:1



-21 GRIP

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PAGE 3GSZ1	DWG NO SK145-0114	REV -
SIZE B	SCALE: 1:4	CATIA
SHEET 4 OF 4		

D

C

B

A